

546

DART AEROSPACE LTD	Work Order:	24699
Description: Bracket Assembly	Part Number:	D3121-043
		D3121-044
Dwg: D3121 Rev. C2 page 1, 3, 5	Qty:	5 Kits
D3121-043 replaces Premier P/N B30-23000-37		
D3121-044 replaces Premier P/N B30-23000-38		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	JL	05.10.26	5
2	MV	Cut (1) blank per D3121-13 & (1) blank per D3121-14 Cut blanks (1.00" x 2.00") x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: M14773	JL	05.11.14	10
3	MV	Machine D3121-13 as per Folio FA329 and Dwg D3121	BG	05.11.16	5
4	QC2	Inspect parts as they come off the CNC machine	BG	05.11.16	5
5	MV	Machine D3121-14 as per Folio FA329 and Dwg D3121	BG	05.11.16	5
6	QC2	Inspect parts as they come off the CNC machine	BG	05.11.16	5
7	MV	Deburr Break all sharp edges 0.005 to 0.015	BG	05.11.16	10
8	MV	Scribe batch number to D3121-13 & D3121-14 at the back face.	BG	05.11.16	10
9	QC5	Second check D3121-13 and D3121-14	SA	05.11.16	10
10	GA	Assemble D3121-043 as per Dwg D3121 Pick: Qty Part Number Description Batch 2 D3121-21 Bolt B 24475B 2 D3121-241 Bearing Assembly B 244777 Identify as D3121-043	BG	05.11.20	2
11	GA	Assemble D3121-044 as per Dwg D3121 Pick: Qty Part Number Description Batch 2 D3121-21 Bolt B 24475B 2 D3121-241 Bearing Assembly B 244777 Identify as D3121-044	BG	05.11.20	10
12	QC5	Inspect work to Step 10 & 11	JL	05.12.23	10
13	ST	Identify and Stock in Spacedoor cell D3121-043 Qty 5 D3121-044 Qty 5	DL	05/12/28	10
14	AC	Parts to Stock and Prorate Cost to parts per Step 13 Cost / part:	SAC	06-01-03	10
15	DC	Close W/O Inspect Level 21	DL	06/01/03	10

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF	
C	05.01.27	Revised Steps 10-11	KJ/JLM	SG

RELEASED
05/05/2021